

Date: Monday, 19/03/2007 10:19:07 AM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 31285  
 Estimate Number : 12281  
 P.O. Number : *N/A*  
 This Issue : 19/03/2007 S.O. No. : *N/A*  
 Prsht Rev. : NC  
 First Issue : *N/A* Type : LARGE FAB ASSY  
 Previous Run : 30221  
 Written By : \_\_\_\_\_  
 Checked & Approved By : \_\_\_\_\_  
 Comment : est rev . A 06.02.09 new issue EC

Drawing Name : RIGHT ARM WELDMENT  
 Part Number : D3354042  
 Drawing Number : D3354 REV.A  
 Project Number : N/A  
 Drawing Revision : A  
 Material : *N/A*  
 Due Date : 26/03/2007

Qty: *(3)* Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D33549 handle socket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

pick:

qty part number description batch  
 1 D3354-9 Handle socket

*B29905 → 3*

*(3)*  
*P/L 07-03-22*

2.0 D33541 inner shaft



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

pick:

qty part number description batch  
 1 D3354-1 Inner shaft

*B30388*

*(3)*  
*P/L 07-03-22*

3.0 D33547 left arm plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

pick:

qty part number description batch  
 1 D3354-7 Left arm plate

*B29904 → 3*

*(3)*  
*P/L 07-03-22*

4.0 D33543 shaft



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

pick:

qty part number description batch  
 1 D3354-3 Shaft

*B30399*

*(3)*  
*P/L 07-03-22*

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Drawing Name: RIGHT ARM WELDMENT

Job Number: 31285

Part Number: D3354042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

TP134

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

TP-134 TENSION PIN

Batch: M16362

Cpl 07-03-22 (3)

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Weld assembly as per dwg D3354

2-Grind welds flush as per dwg D3354

Cpl 07-03-22 (3)

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

M 07/03/22 (3)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

M 07/03/22 (3)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1-Mask areas indicated on dwg D3354

2-Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

M18052

M-L 07/03/23

(3X)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

L 07/3/26

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

L 07/3/26 58 07/03/26 (3)

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RIGHT ARM WELDMENT

Job Number: 31285

Part Number: D3354042

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC21

FINAL INSPECTION/W/O RELEASE



(3)

Comment: FINAL INSPECTION/W/O RELEASE

07/03/07

Job Completion



4 of 03.27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

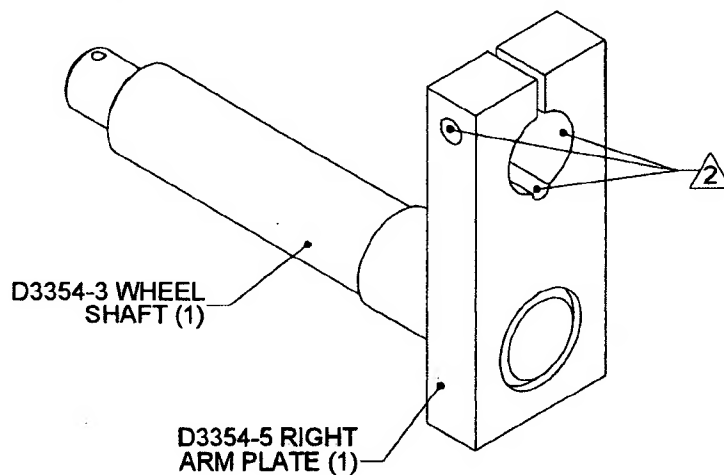
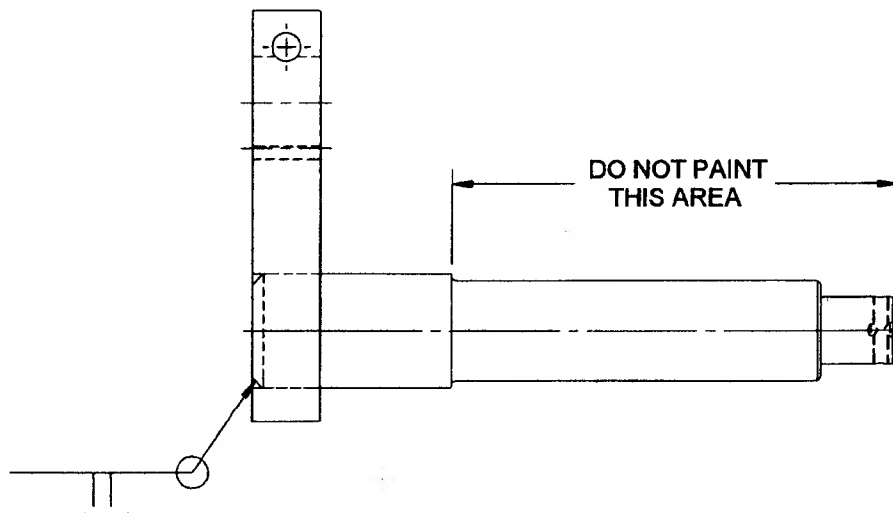
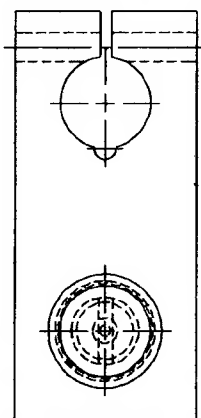
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3354</b>	REV. B SHEET 2 OF 7
DATE <b>07.02.02</b>	TITLE <b>LEFT ARM WELDMENT</b>		SCALE 1:2

**RELEASED**  
07.02.02**REFERENCE ONLY****D3354-043 RIGHT ARM WELDMENT****NOTES:**

- 1) WELD PER DART QSI 004
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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